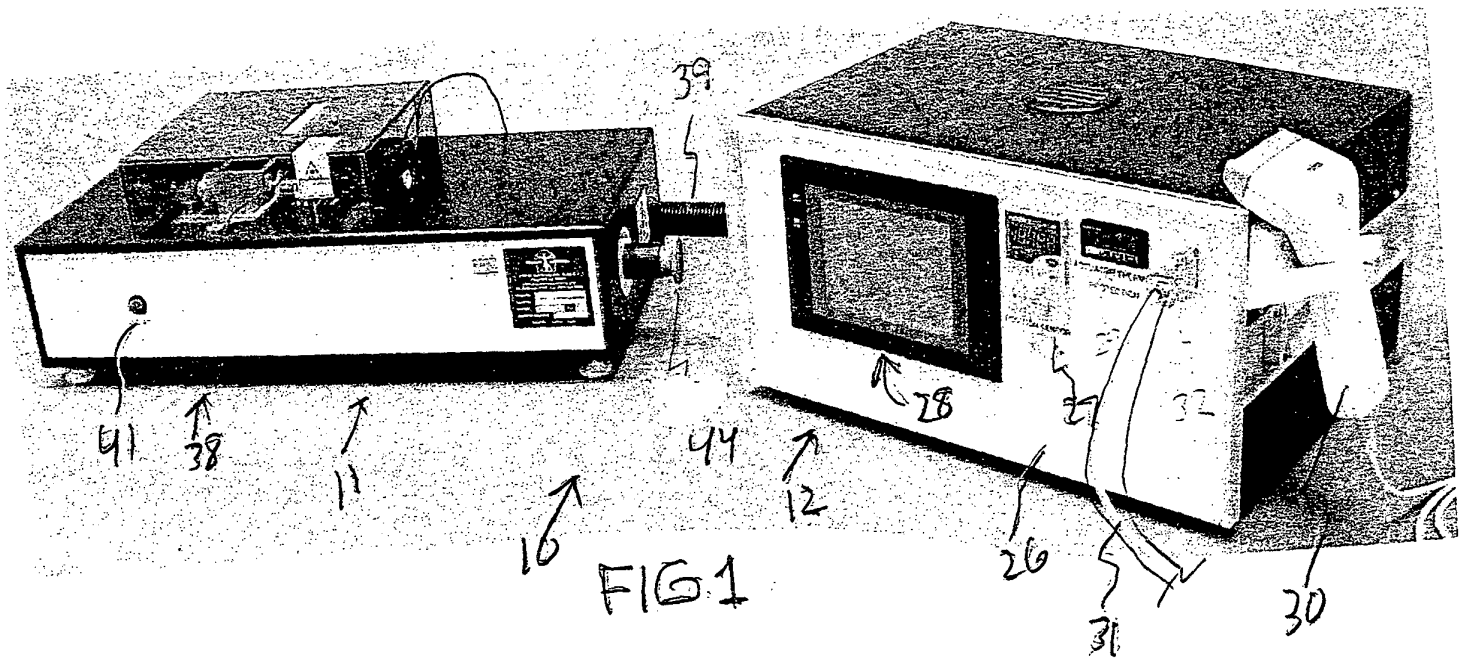
39
41
38
11
44
12
10
28
27
32
26
31
30

FIG 1

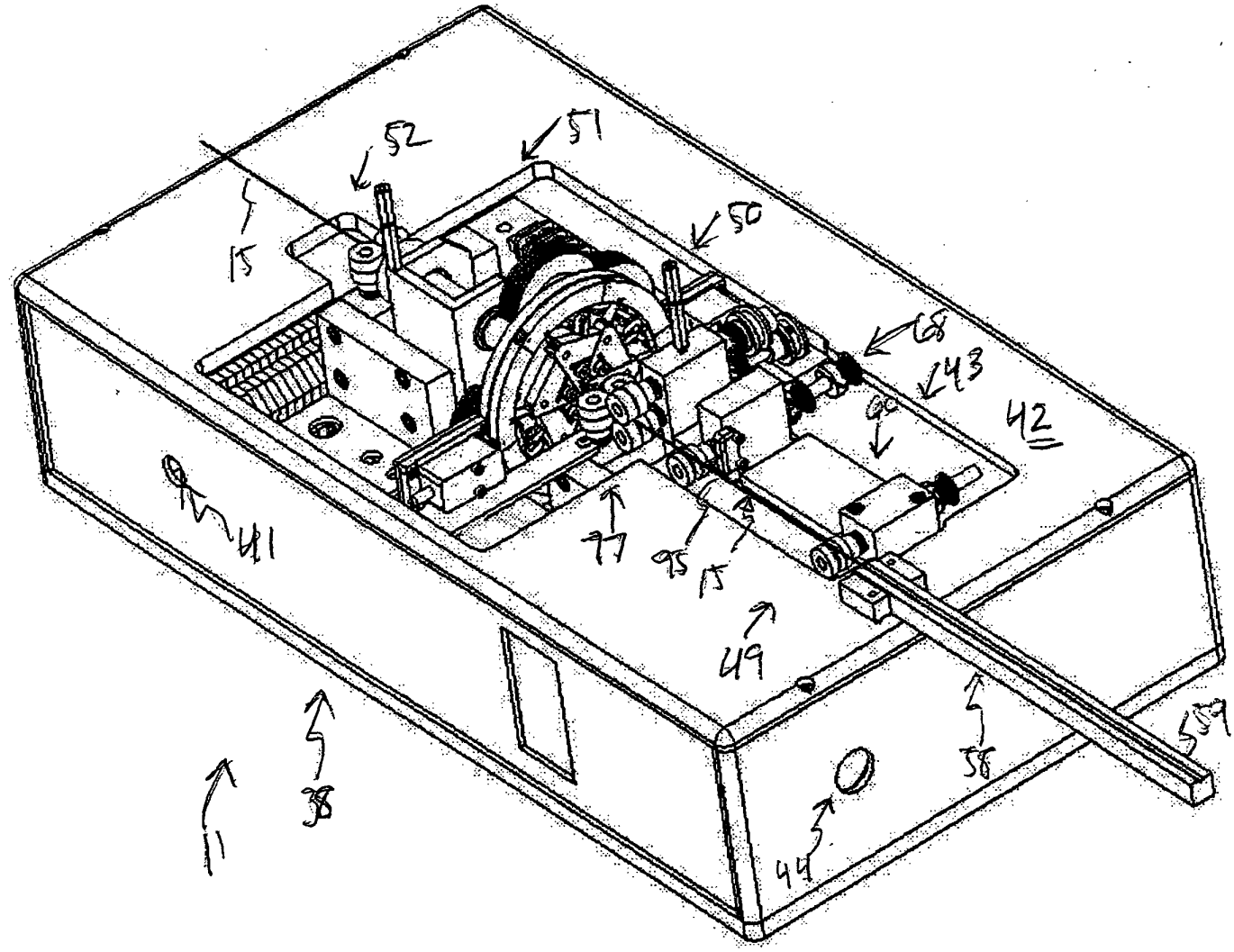
52
51
50
15
68
43
42
41
77
95
15
49
58
59
38
11
44

FIG 2

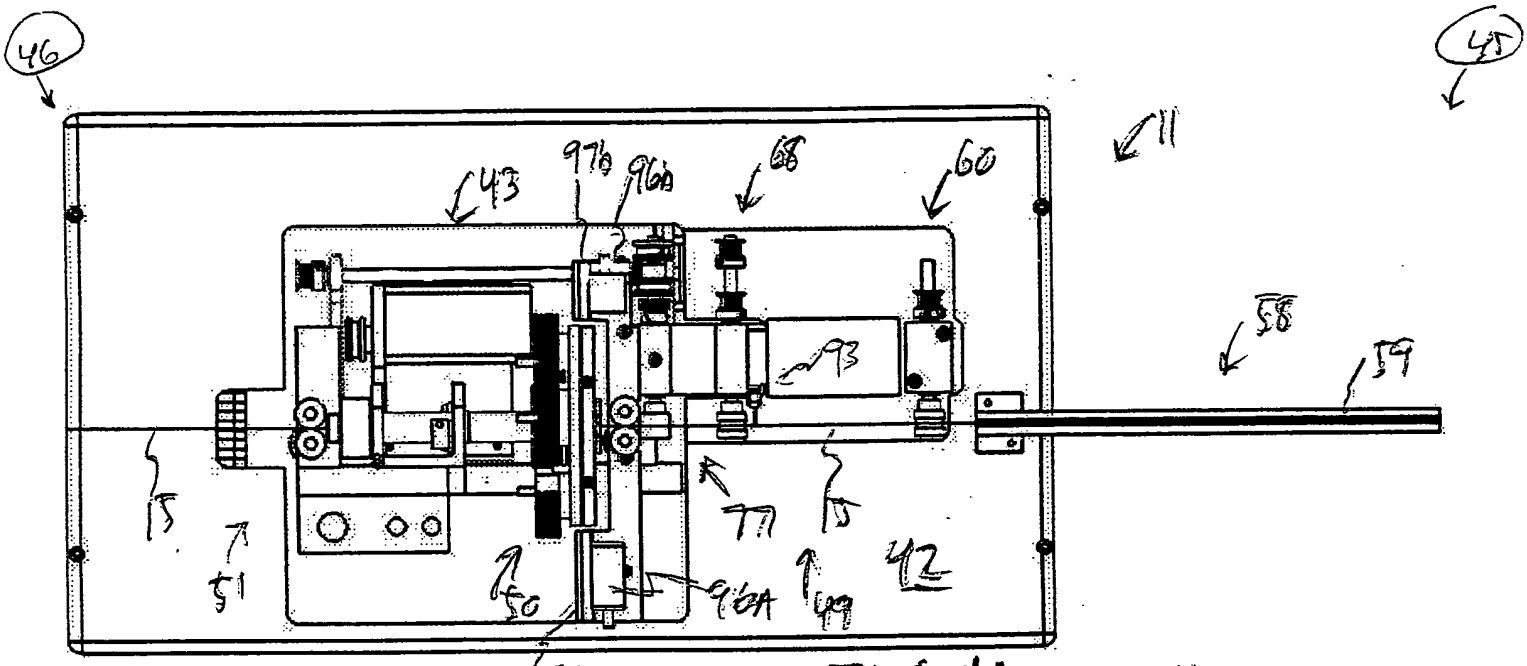

FIG. 4

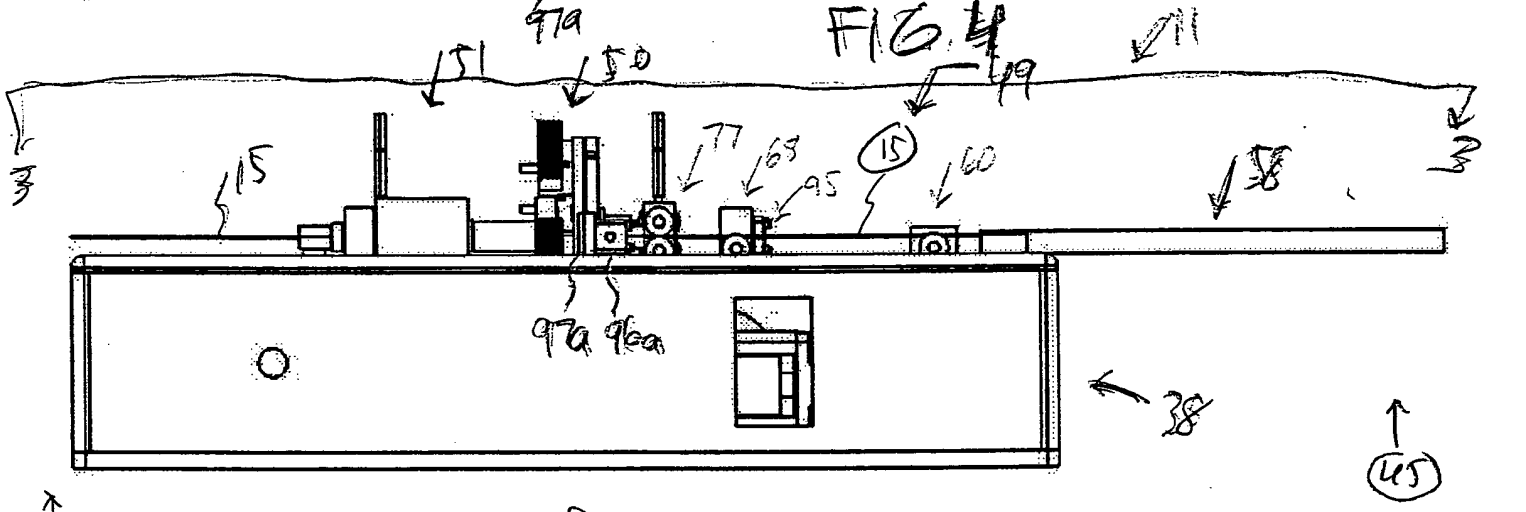

FIG 3

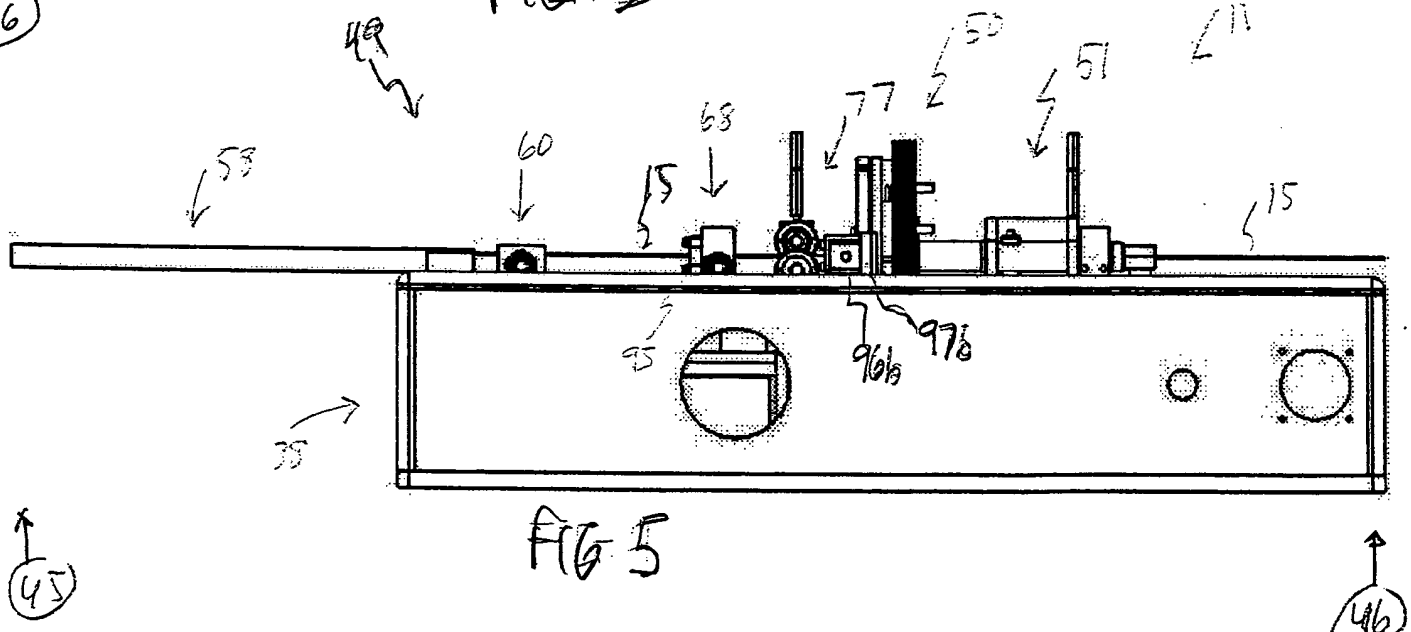

FIG 5

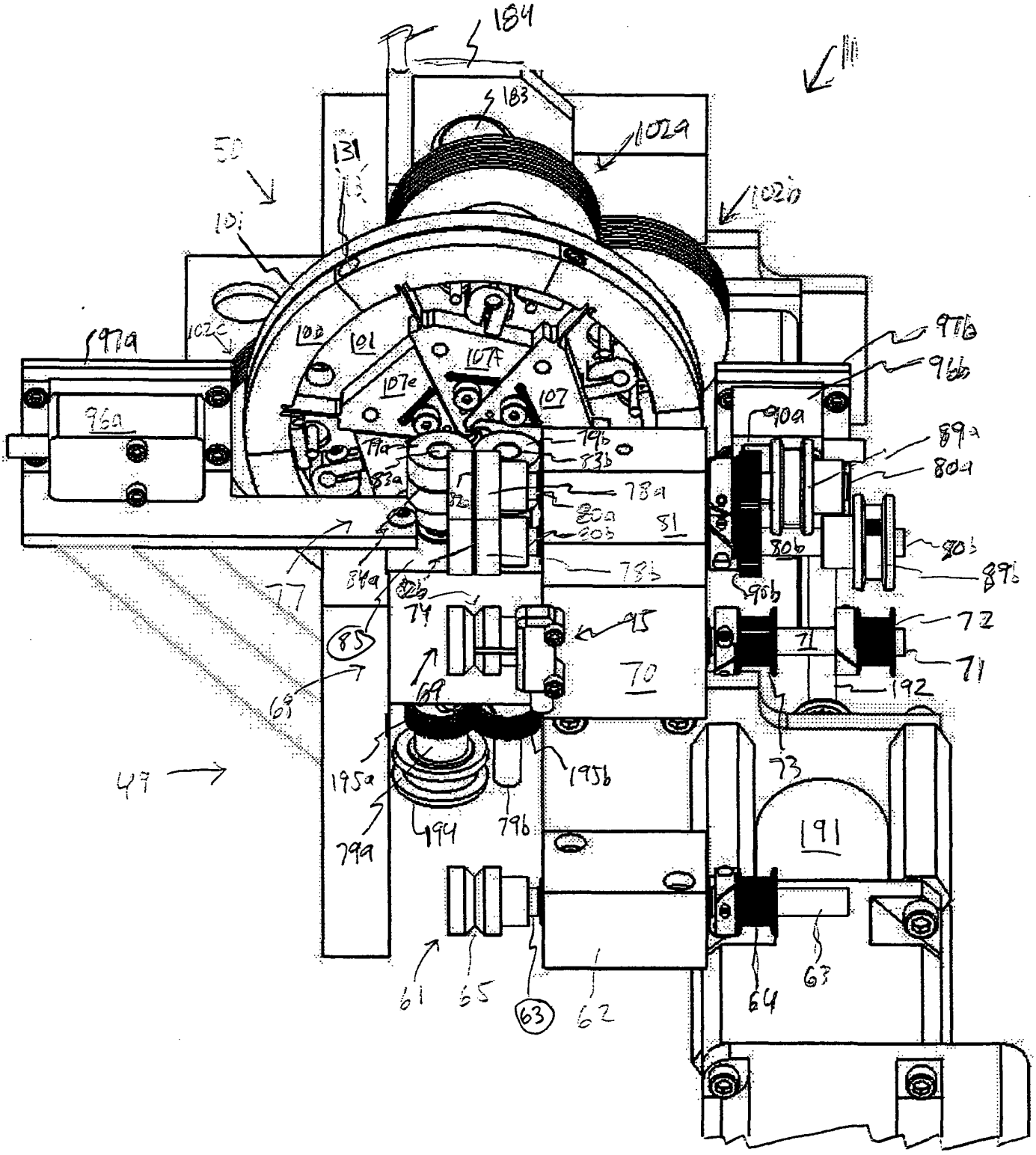

FIG. 6

impact end zone

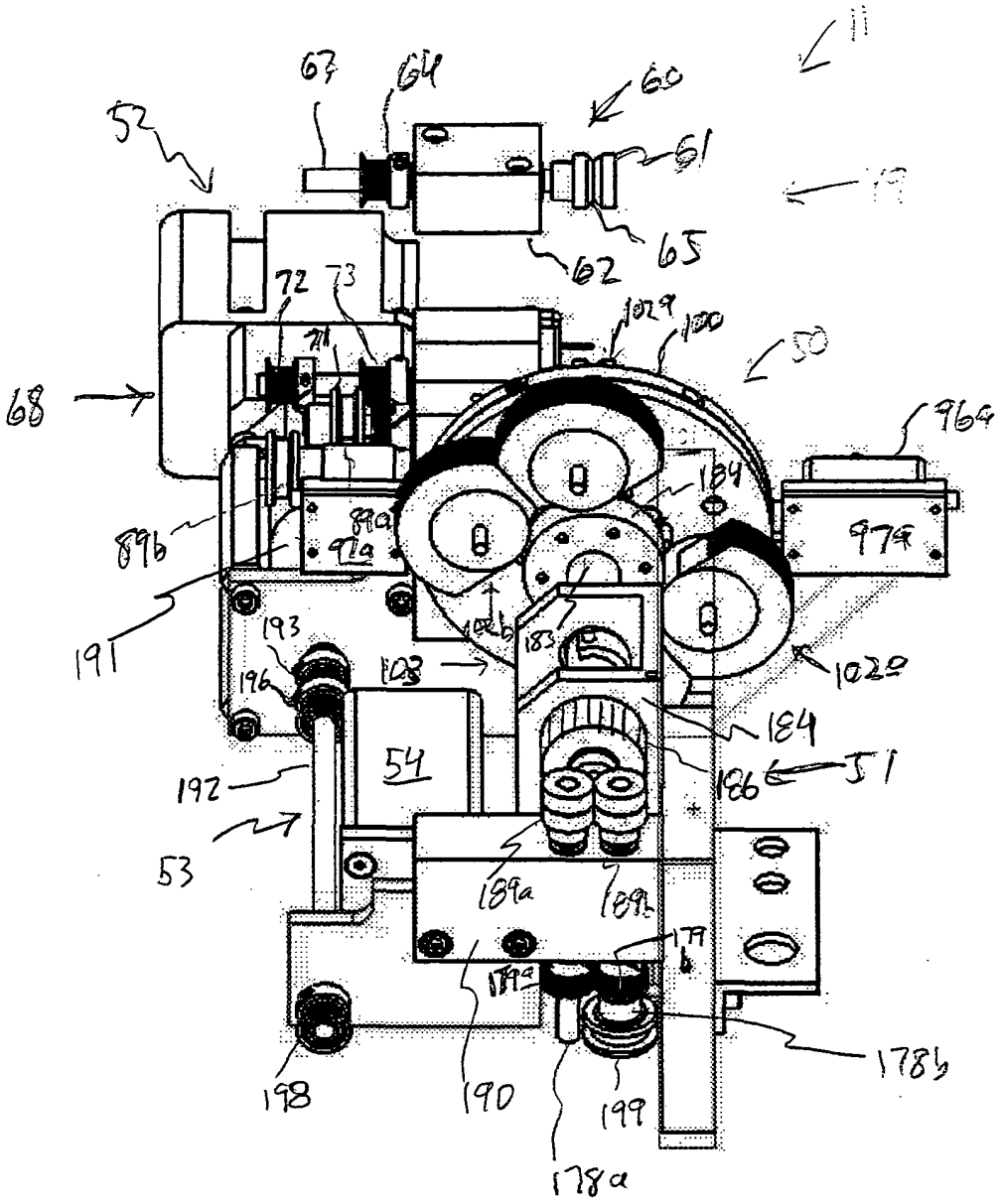
11
67
64
60
52
61
19
65
62
72
73
71
102g
100
50
68
96a
89b
89a
97a
184
97g
193
196
191
102b
183
103
102a
184
54
186
51
192
53
189a
189b
177b
177a
178b
198
190
199
178a

FIG. 7

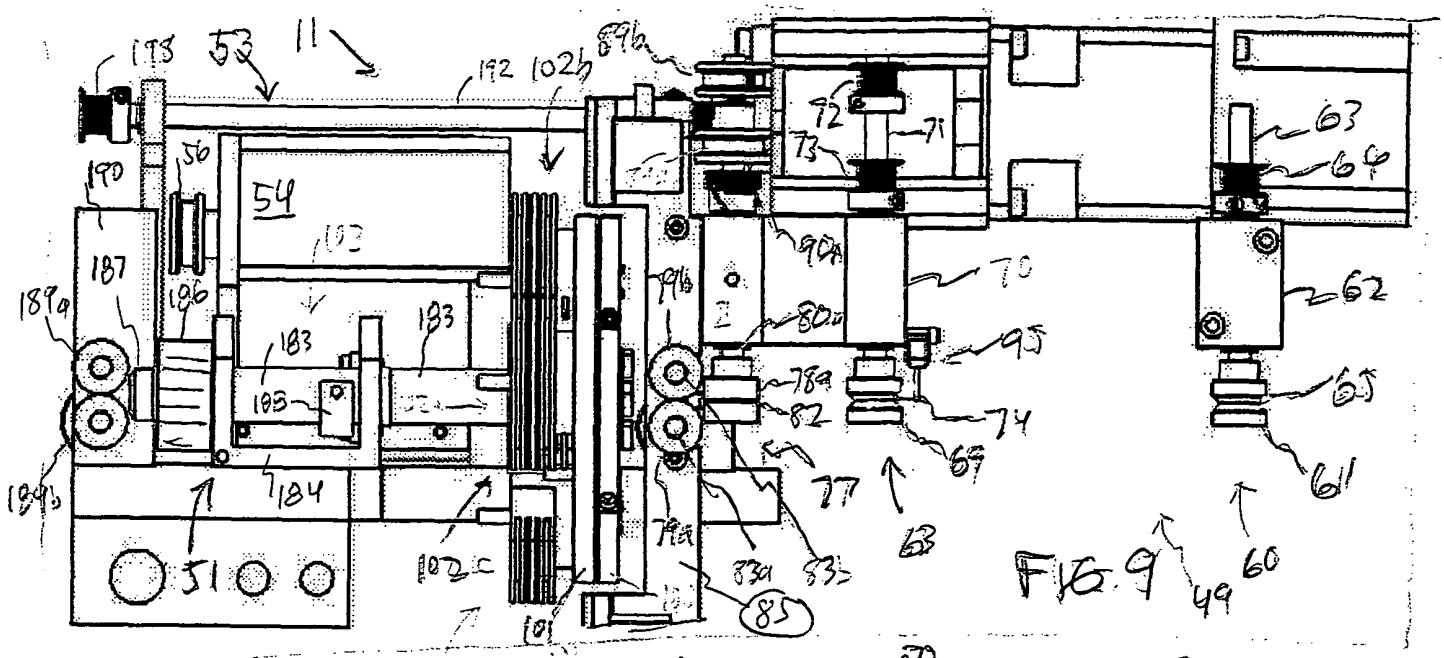

FIG. 9

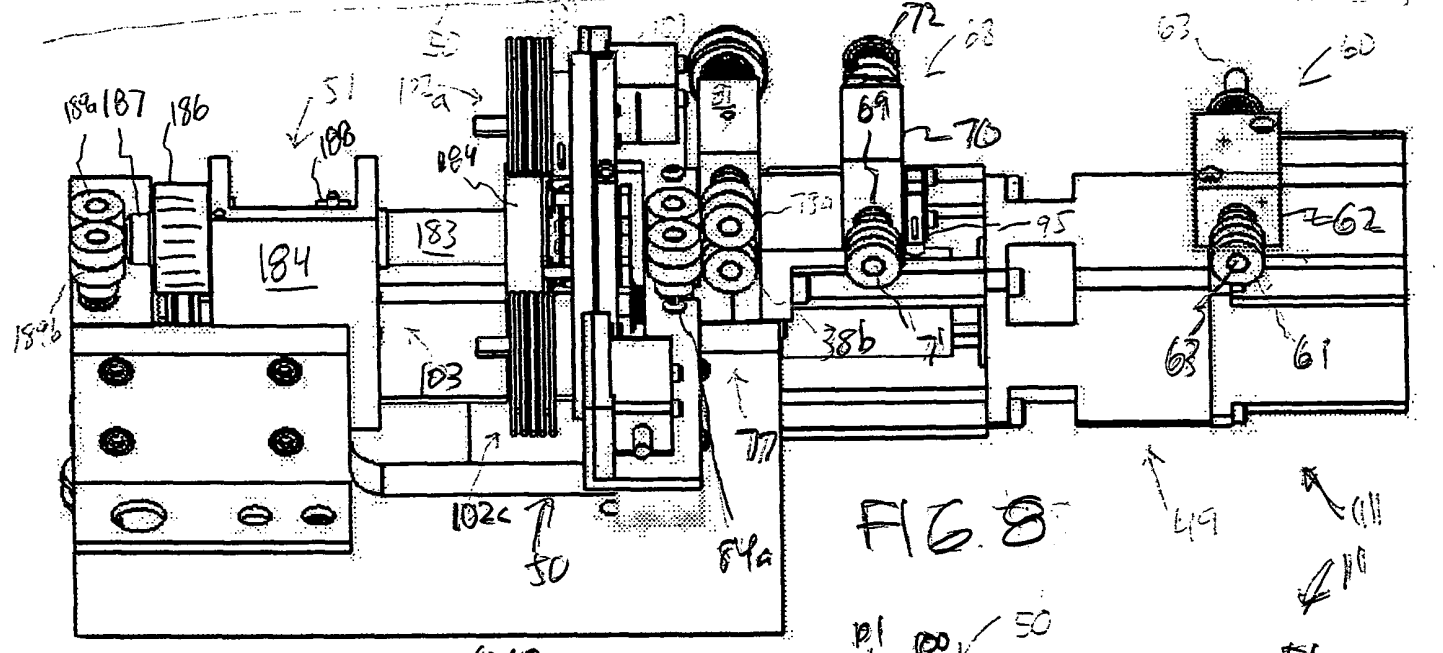

FIG. 8

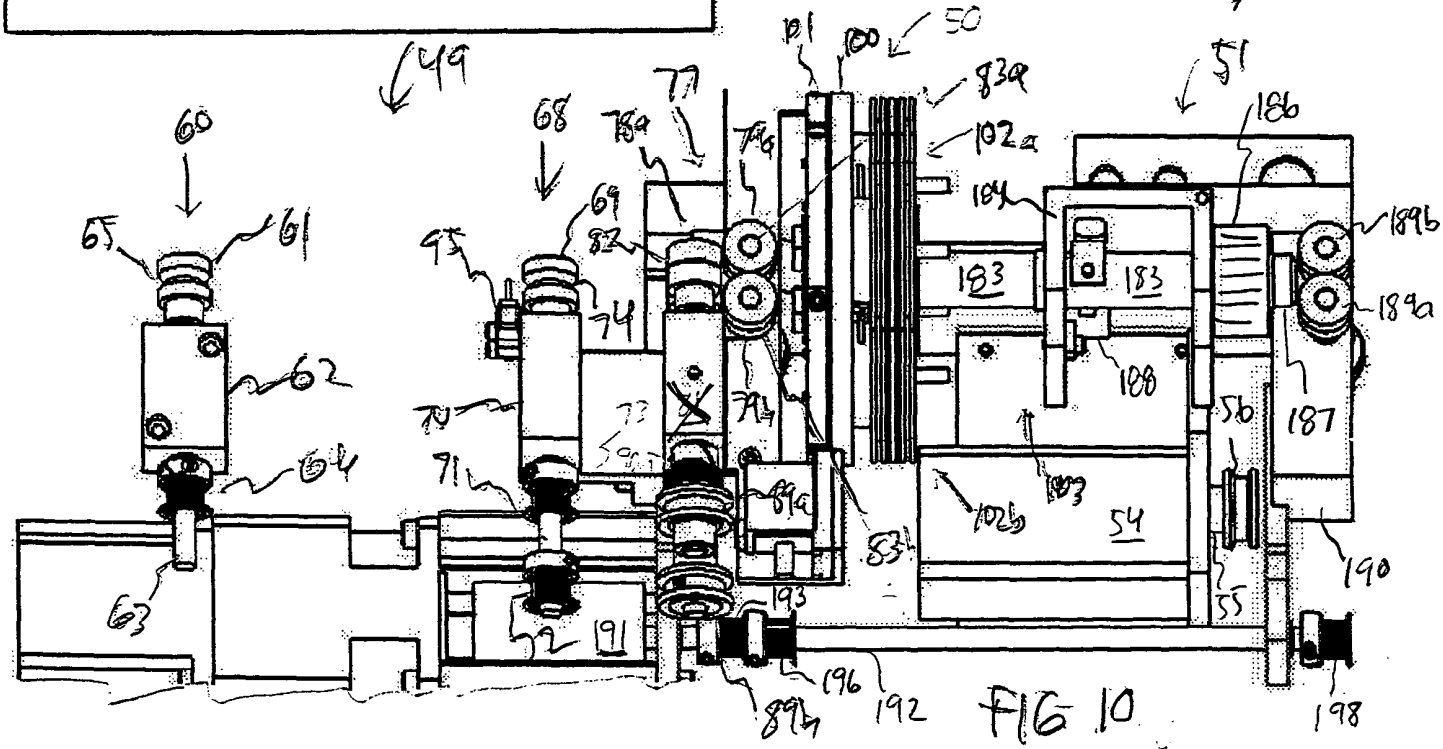

FIG. 10

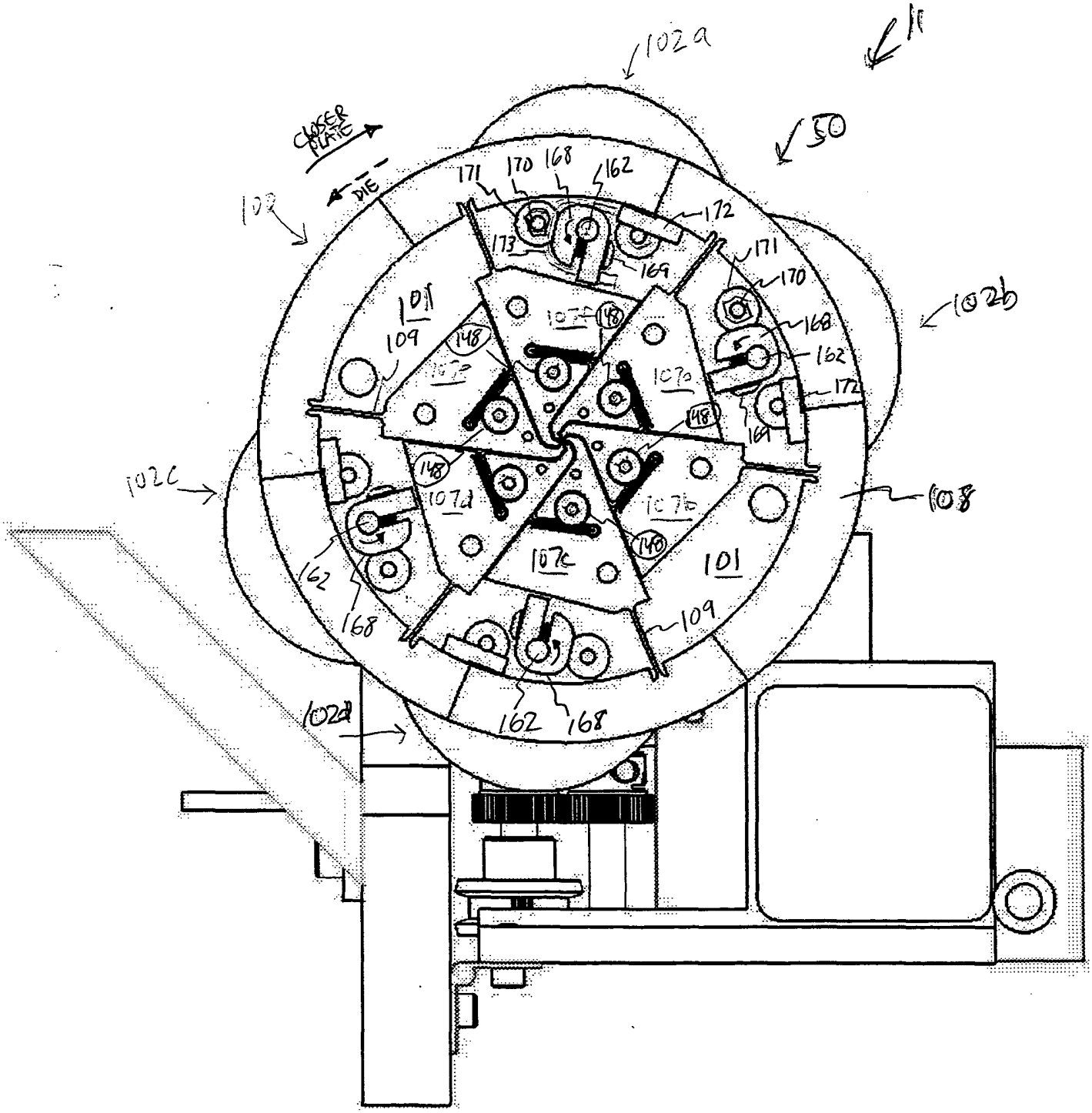
102a
50
CLOSER PLATE
DIE
102
171
170
168
162
172
173
169
101
109
148
107a
107b
107c
102b
102c
102d
108

FIG 11

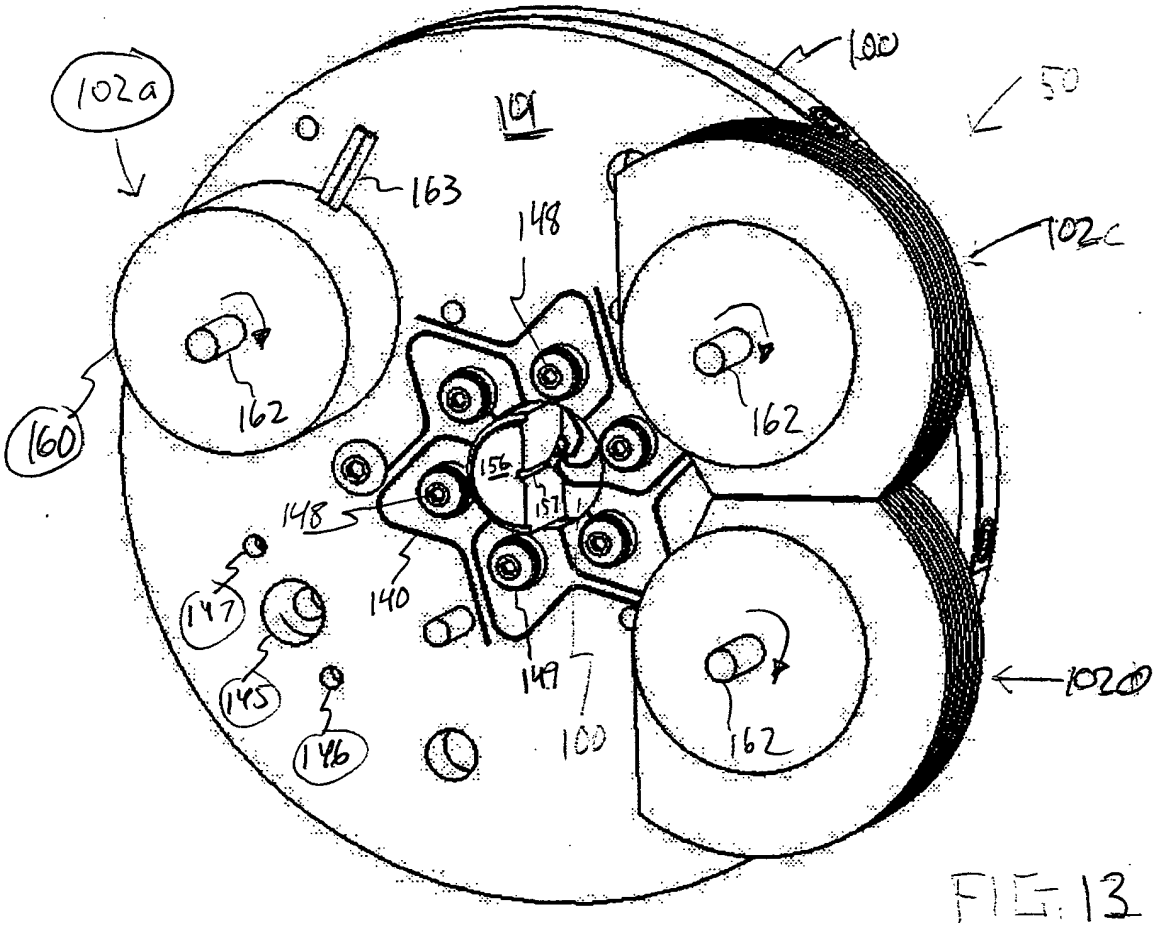
102a
100
50
101
163
148
102c
160
162
162
156
157
148
147
140
149
145
146
100
162
102d

FIG. 13

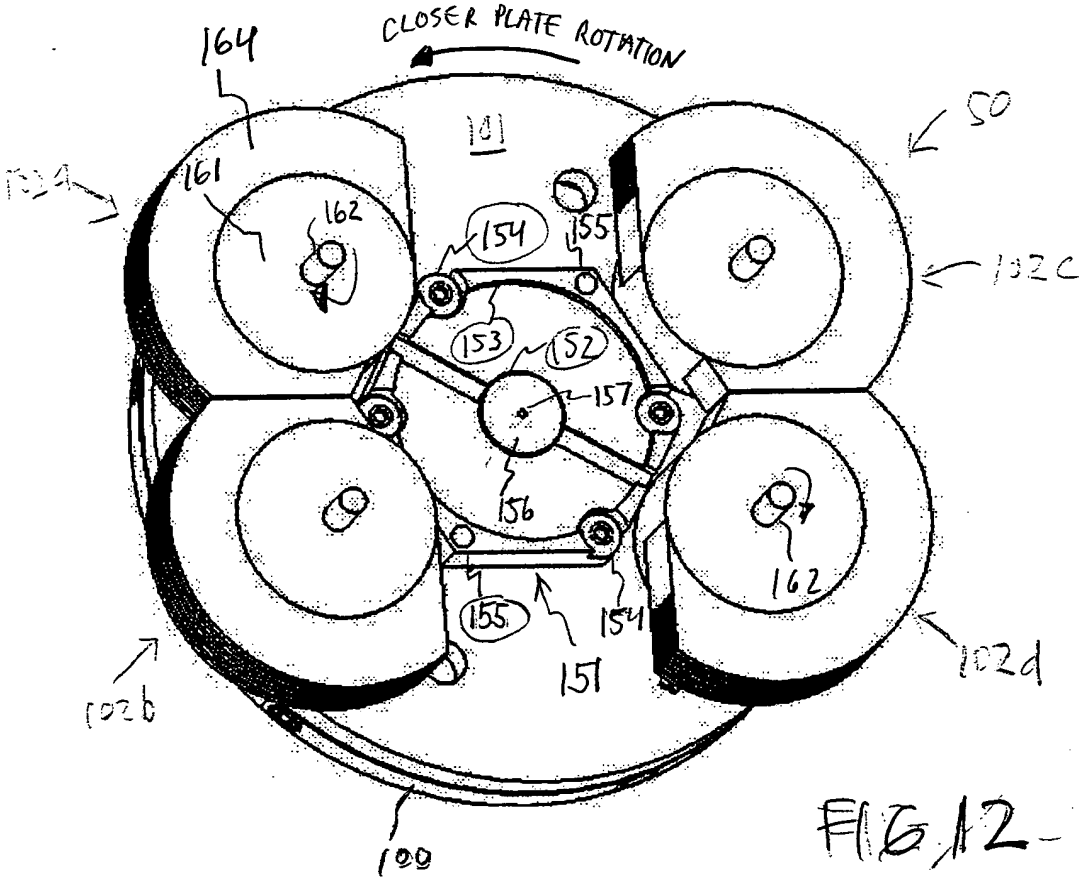
164
CLOSER PLATE ROTATION
50
101
161
162
154
155
102c
153
152
157
156
155
154
151
162
102d
102b
100

FIG. 12

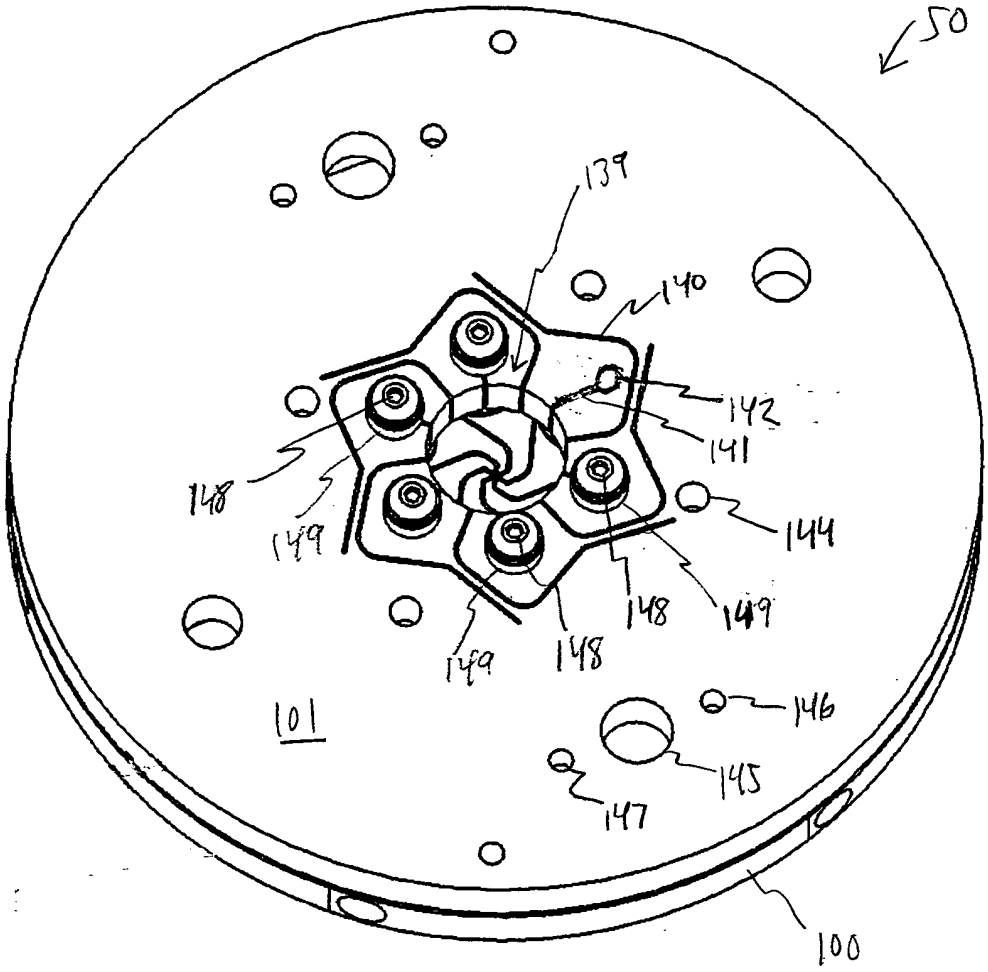
50
139
140
142
141
148
149
144
148
149
149
148
101
146
145
147
100

FIGURE 14

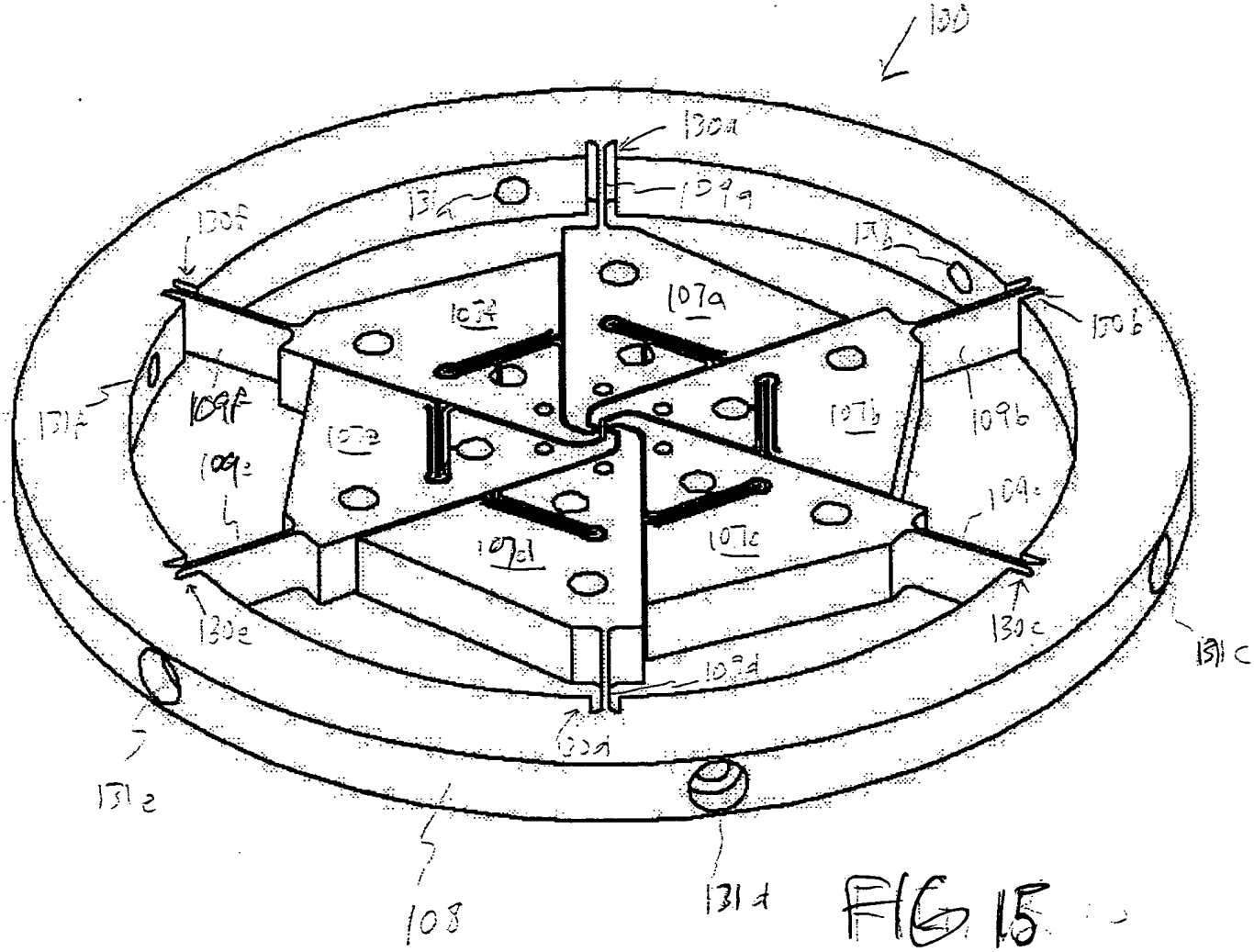
100
130a
109a
131a
130b
107a
107b
109b
131b
130f
109f
107f
107e
109e
131f
130e
107d
107c
109c
130c
131c
109d
130d
131e
108
131d

FIG 15

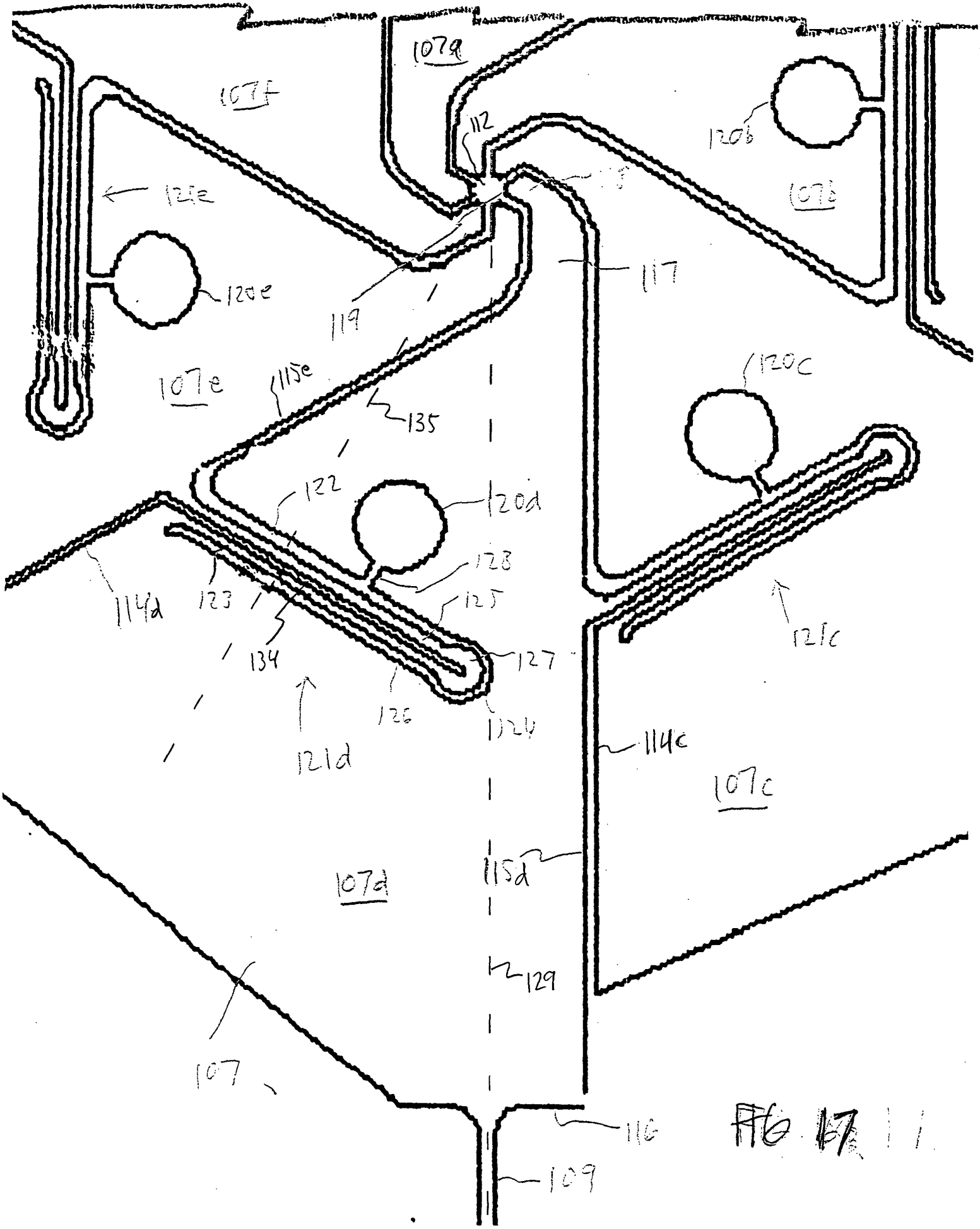
107g
107f
112
120b
107b
125e
120e
117
119
107e
115e
135
120c
122
120d
128
114d
123
125
134
127
121c
126
124
121d
114c
107c
115d
107d
129
107
116
109

FIG 17

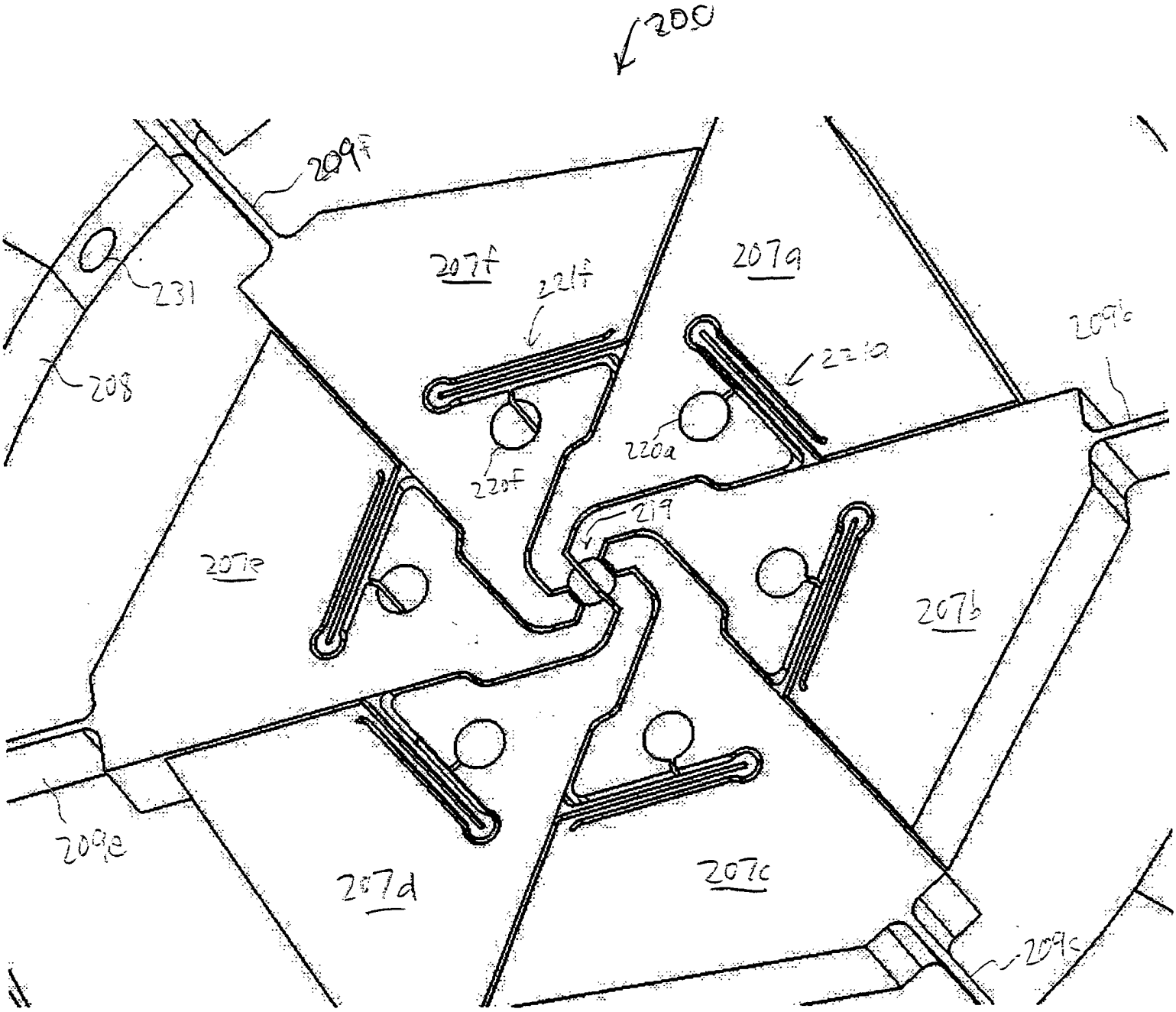
200
209f
231
207f
221f
207g
208
220f
220a
209g
219
207e
207b
209e
207d
207c
209c

FIG 18

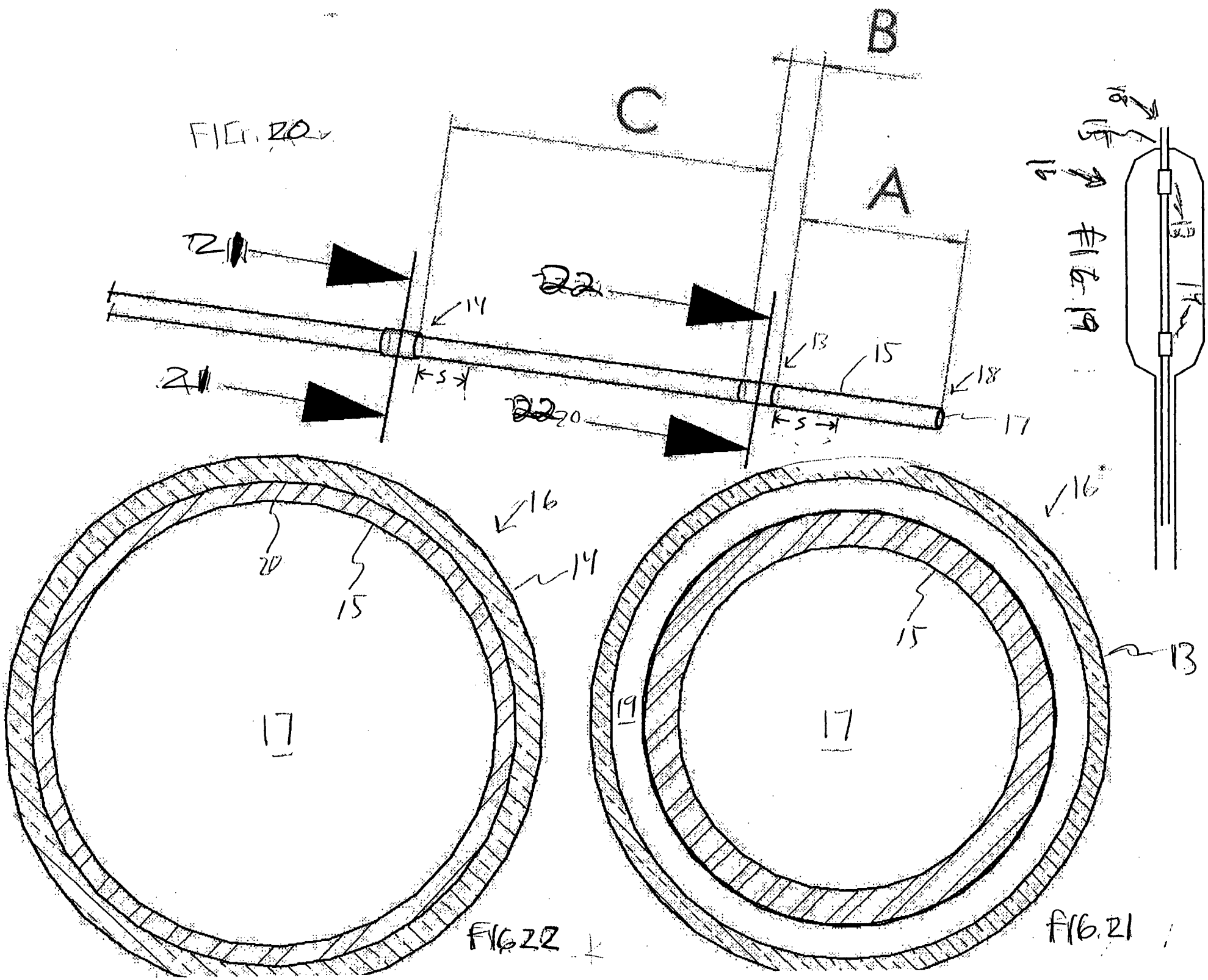

FIG. 20

FIG. 19

FIG. 22

FIG. 21

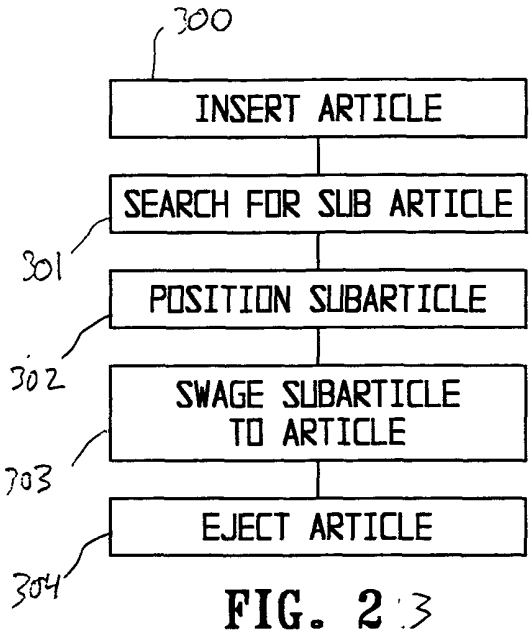

FIG. 23

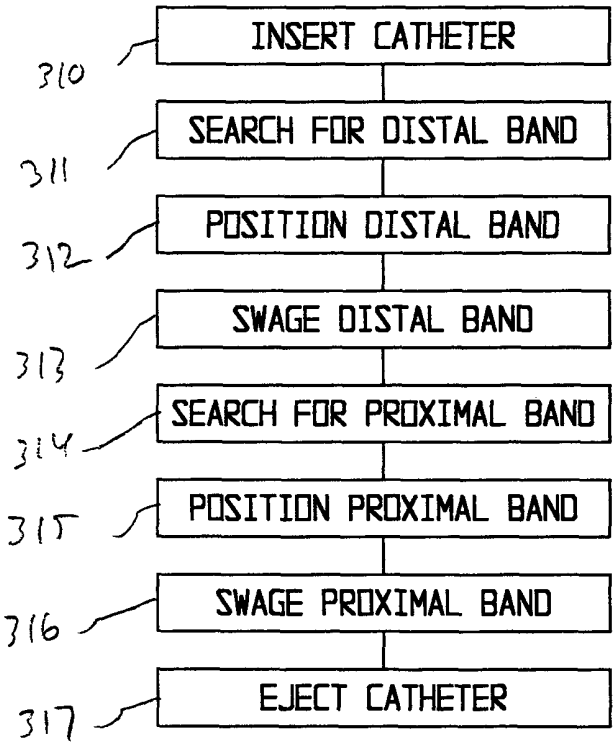

FIG. 24

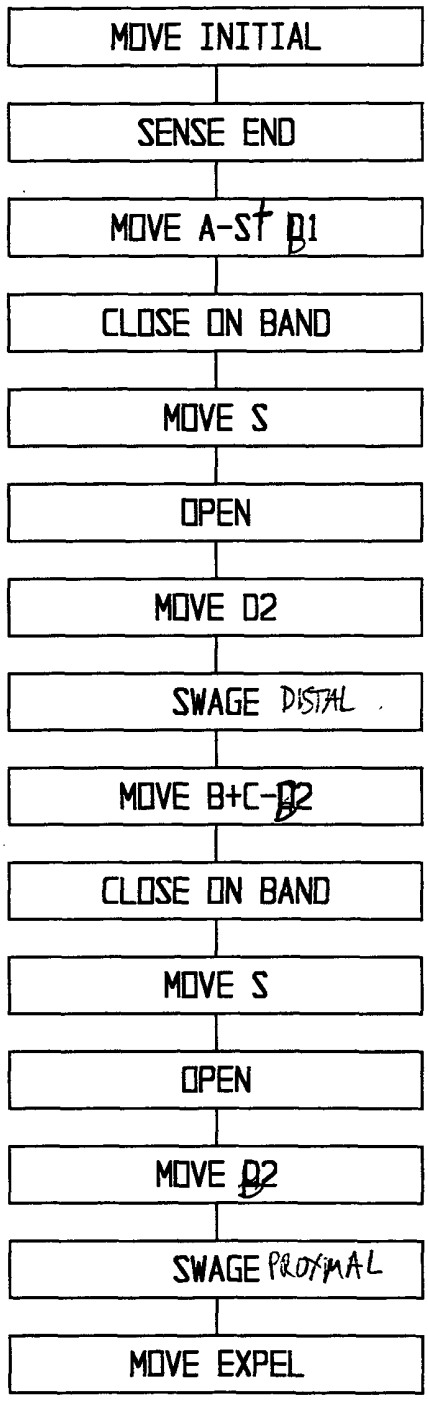

FIG. 25